

Date: Tuesday, 11/29/2005 10:25:23 AM
 User: Linda Lacelle

Process Sheet

Customer :	CC-DAR01 Dart Aerospace Ltd.	Drawing Name :	DISASSEMBLE	
Job Number :	24978			
Estimate Number :	10804			
P.O. Number :		Part Number :	Z_CUSTOM	
This Issue :	11/29/2005	S.O. No. :		
Prsht Rev. :	NC	Drawing Number :	Z_CUSTOM	
First Issue :	11/29/2005	Project Number :		
Previous Run :	00015	Drawing Revision :		
Written By :		Material :		
Checked & Approved By :		Due Date :	12/6/2005	Qty: Um: Each
Comment :				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Qty
Comment: SMALL & MEDIUM FAB RESOURCE 1

199
 DISASSEMBLE 1 X D3137-041 B23576 : - remove

405 190
 1 X D3137-1 B18659

196
 1 X D3137-3 B 17477

197
 1 X D3137-5 M10536

198
 1 X MS24694S101 16 241

ADJUST INVENTORY

SB 05/11/29

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1 *MS24694S101 (241)*

ID & STOCK

D3137-5 (402)

SB 05/11/29

3.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

546 05/11/30

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	18659
Description: Bracket assembly	Part Number:	D3137-041
Drawing: D3137 Rev.A1	Qty:	15

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING DC	Issue Work Order traveller	KD	03.01.15	15
2	STORES GA	Pick: Qty Part number Description Batch 1 D3137-1 Bracket B18659 1 D3137-3 Guide B17477 B18680 1 D3137-5 Washer M10536-17 1 MS24694-S101 Screw M11735		030319	15
3	METAL GA	Assemble as per dwg. D3137-041		030324	15
4	QC5	Inspect Level 7 work to step 8		03.04.01	15
5	STORES ST	Identify and stock as D3137-041		03-04-02	15
6	EXPEDITING	Close W/O Inspect level 21 Cost/part 24.01 545 03/04/02 15		03.04.02	-

Rev	Date	Change	Revised By	Approved
A	02.05.16	New Issue	NG	02-05-30
A1	03.01.14	Modify procedures	RF	03.01.14

RELEASED

02/05/30

2	ST	Pick: Qty Part Number Description Batch 1 B30-23000-105/106 Bracket M10536-17		03/03/10	15
3	MV	Machine slot per Dwg. D3137 Detail B. Identify as D3137-1. Engrave Dart P/N. Remove Premier ID.		03/03/10	15
4	QCZ	Inspect parts as they come off the CNC machine		03/03/10	15
5	MV	Deburr		03/03/10	15
6	QC8	Second check		03.03.12	15

* TALK TO DAND SHEPHERD BEFORE DOING. 03.01.14

ERIC CHAMBERLAIN CAME TO
SEE ME BEFORE STARTING

REFERENCE ONLY

03.04.02

REFERENCE ONLY

DART AEROSPACE LTD	Work Order:	23576
Description: Custom W/O to rework bracket	Part Number:	D3137-041
Dwg: D3137 Rev. D PAGE 1 of 2		
Ref: N/A		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	KJ	05.06.14	
2	ST	Remove from store. Qty Part Number Description Batch D333T-041 Bracket Ass'y B 18659 RF 05.08.07 D3137-041	E	05.08.07	10
3A	MV	Disassemble and cut to 0.250" in length at Ø0.560 as per dwg. Save MS24694-S101 screws in store with batch: M11735	E	05.08.07	10
4	QC5	Inspect work to Step 3.	Z	05.09.21	3 PTO
5	MV	Assemble as per dwg. Qty Part Number Description Batch 9 MS24694-S98 Screw M16255 05.09.26 M18431	ml	05.09.26	9 PTO
6	ST	Identify and Stock D3137-041.	ml	05.09.26	9
7	AC	Charge to project number P602-2250 Cost / part: 29.04	Svt	05.09.29	9
8	DC	Close W/O 28.13 Inspect Level 21	PD	05/09/28	9

(Note: Attach a copy of Custom W/O to each of the W/O's listed in Step 2 above)


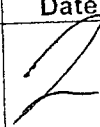
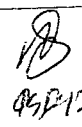
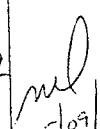
Rev	Date	Change	Revised By	Approved
A	05.06.14	New Issue	KJ/RF	

3B	GA	Debur
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E	05.09.21	10
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES		
DATE	STEP	PROCEDURE CHANGE	By	Date

NCR:		WORK ORDER NON-CONFORMANCE (NCR)				
DATE	STEP	Description of NC Section A	Corrective Action Section B		Veri Sc	
			Initial Design Mgr	Action Description Design Mgr		Sign & Date
05-09-21	3A	1x D3137-1 is machined +0.30 under tolerance.	 05/09/21	Scrap: destroy	 05-09-21	05-
05/01/22	5	Some parts missing to finish the assy	 05/01/22	Pick in store 3x D3137-3 Guide <u>1323729</u> 5x D3137-5 Washer <u>M10S36-17</u>	 05/09/26	

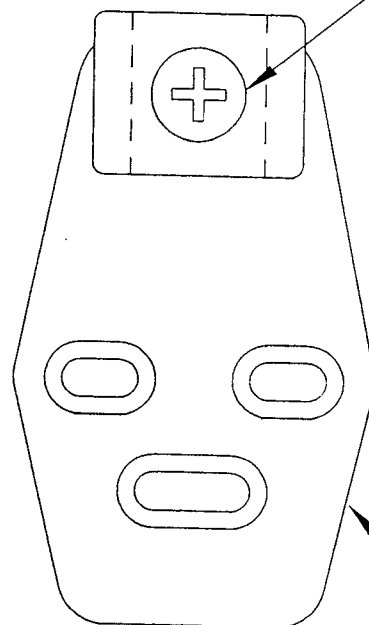
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: _____
 QA: N/C Closed: _____

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD	
		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. D
		D3137	SHEET 1 OF 4
DATE		TITLE	SCALE
04.11.03		BRACKET ASSEMBLY	1:1
A	02.04.17	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP.	
C	03.08.15	ADD -043	
D	04.11.03	RE-DESIGN D3137-5; CHANGE DIMS	

RELEASED
04.11.23



05.09.26
05.06.14
598 S100
MS24694-S104 SCREW
D3137-5 WASHER
D3137-3 GUIDE
INSTALL ON SAME SIDE AS C'SINKS
(OPPOSITE SIDE FROM RIDGES)

SHOP COPY

RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 23576

D3137-1 BRACKET (-041 SHOWN)
OR
D3137-7 BRACKET (-043 SIMILAR)